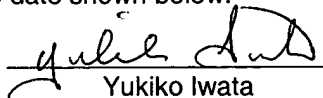


PATENT
TS7594 (US)
YI:EM

Hereby certify that this correspondence is being deposited with the United States Postal Service as first class mail in an envelope addressed to Commissioner for Patents, P. O. Box 1450, Alexandria, VA 22313-1450 on or before the date shown below.


Yukiko Iwata
Date: April 28, 2004

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re application of)	
)	
RICHARD H. CLARK, CHRISTOPHER MORLEY,)	
and PAUL A. STEVENSON)	
)	
Serial No. 10/706,594)	Group Art Unit: 1714
)	
Filed November 12, 2003)	April 28, 2004
)	
DIESEL FUEL COMPOSITIONS)	
_____)	

COMMISSIONER FOR PATENTS
P. O. Box 1450
Alexandria, VA 22313-1450

Sir:

CLAIM TO PRIORITY

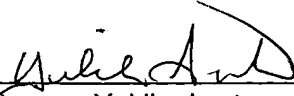
Applicants reaffirm the claim for the benefit of filing date of the following foreign patent application referred to in Applicants' Declaration:

European application Serial No. 02257805.8 filed November 13, 2002

A copy of the application certified by the European Patent Office is enclosed.

Respectfully submitted,

RICHARD H. CLARK, CHRISTOPHER MORLEY,
and PAUL A. STEVENSON

By 
Attorney, Yukiko Iwata
Registration No. 35,748
(713) 241-5593

P.O. Box 2463
Houston, Texas 77252-2463

THIS PAGE BLANK (USPTO)



**Europäisches
Patentamt**

**European
Patent Office**

**Office européen
des brevets**

TJ 7594

Bescheinigung

Certificate

Attestation

Die angehefteten Unterlagen stimmen mit der ursprünglich eingereichten Fassung der auf dem nächsten Blatt bezeichneten europäischen Patentanmeldung überein.

The attached documents are exact copies of the European patent application described on the following page, as originally filed.

Les documents fixés à cette attestation sont conformes à la version initialement déposée de la demande de brevet européen spécifiée à la page suivante.

Patentanmeldung Nr. Patent application No. Demande de brevet n°

02257805.8

Der Präsident des Europäischen Patentamts;
Im Auftrag

For the President of the European Patent Office

Le Président de l'Office européen des brevets
p.o.

R C van Dijk

THIS PAGE BLANK (USPTO)



Anmeldung Nr:
Application no.: 02257805.8
Demande no:

Anmeldetag:
Date of filing: 13.11.02
Date de dépôt:

Anmelder/Applicant(s)/Demandeur(s):

SHELL INTERNATIONALE RESEARCH
MAATSCHAPPIJ B.V.
Carel van Bylandtlaan 30
2596 HR Den Haag
PAYS-BAS

Bezeichnung der Erfindung/Title of the invention/Titre de l'invention:
(Falls die Bezeichnung der Erfindung nicht angegeben ist, siehe Beschreibung.
If no title is shown please refer to the description.
Si aucun titre n'est indiqué se référer à la description.)

Diesel fuel compositions

In Anspruch genommene Priorität(en) / Priority(ies) claimed /Priorité(s)
revendiquée(s)
Staat/Tag/Aktenzeichen/State/Date/File no./Pays/Date/Numéro de dépôt:

Internationale Patentklassifikation/International Patent Classification/
Classification internationale des brevets:

C10L/

Am Anmeldetag benannte Vertragstaaten/Contracting states designated at date of
filing/Etats contractants désignées lors du dépôt:

AT BE BG CH CY CZ DE DK EE ES FI FR GB GR IE IT LI LU MC NL PT SE SK TR

THIS PAGE BLANK (USPTO)

Diesel fuel compositions

The present invention relates to diesel fuel compositions, particularly aqueous diesel fuel emulsions, more particularly in which the fuel is a Fischer-Tropsch derived fuel, their preparation and their use in
5 compression ignition engines.

Hydrocarbon-water emulsions have been known for many years and have many uses, including that of fuel-water emulsions.

Such fuel-water emulsions have a number of
10 advantages.

For example, in *"NO_x Reduction with EGR in a Diesel Engine Using Emulsified Fuel"*, Y. Yoshimito et al., SAE Paper 982490, 1998, it is described how from environmental concerns reductions in NO_x and particulate
15 emissions from diesel engines had been mandated in recent years. It states that diesel engines using water-in-gas oil emulsified fuel have shown simultaneous improvements in NO_x, smoke and fuel consumption.

In *"Low Emission Water Blend Diesel Fuel"*, D.T. Daly et al., *Symposium on New Chemistry of Fuel Additives*,
20 219th National Meeting, American Chemical Society, 2000, it is described that the addition of water to diesel fuel lowers emissions of particulates by serving as a diluent to the key combustion intermediates, and decreases NO_x by
25 lowering combustion temperatures through its high heat of evaporation.

In *"AQUAZOLETM: An Original Emulsified Water-Diesel Fuel for Heavy-Duty Applications"*, Barnaud et al., SAE Paper 2000-01-1861, 2000, it is described that the
30 advantages of injecting water into an internal combustion

engine included raising viscosity levels, removal of sediment, and reduction of nitrogen oxide emissions by reducing combustion temperature. There is also specific reference to reduction in black smoke and particulates emissions.

WO-A-99/13028 relates to emulsions comprising a Fischer-Tropsch derived liquid hydrocarbon, a non-ionic surfactant and water, and states that such emulsions are easier to prepare and more stable than the corresponding emulsions with petroleum derived hydrocarbons. There is specific reference to such emulsions having better emission characteristics than petroleum derived emulsions. However, WO-A-99/13028 is concerned with emulsions in which water is the continuous phase, i.e. oil-in-water emulsions.

WO-A-99/63025 relates to aqueous fuel compositions which exhibit reduced NO_x and particulate emissions. It describes how the rates at which NO_x are formed is related to the flame temperature during combustion in an engine. It describes how the flame temperature can be reduced by the use of aqueous fuels, i.e. incorporating both water and fuel into an emulsion. However, it indicates that problems that may occur from long-term use of aqueous fuels include precipitate deposition. It is described that water preferably functions as the continuous phase of the emulsion. Example 5 therein refers specifically to the test engine being modified to run a fuel-in-water emulsion. Therefore, although there is reference in said Example 5 to a fuel emulsion in which the diesel fuel was Fischer-Tropsch diesel, it is clearly a fuel-in-water emulsion. It also indicates that a significant barrier to the commercial use of aqueous fuel emulsions is emulsion stability.

As described in "The performance of Diesel Fuel manufactured by the Shell Middle Distillate Synthesis process", Clark et al., Proceedings of 2nd Int.

Colloquium, "Fuels", Tech, Akad. Esslingen, Ostfildern, Germany, 1999, the diesel cut from the SMDS process has very good cetane quality, low density, plus negligible sulphur and aromatics contents, such properties making it potentially valuable as a diesel fuel with lower emissions than conventional automotive gas oil (AGO).

"The performance of Diesel fuel manufactured by Shell's GtL technology in the latest technology vehicle", Clark et al., Proceedings of 3rd Int. Colloquium, "Fuels", Tech, Akad. Esslingen, Ostfildern, Germany, 2001 describes SMDS diesel product and discusses the emissions benefits.

GB-A-2308383 describes water-in-oil emulsions in middle distillate fuel, particularly diesel fuel. It is directed to the reduction of emissions by the inclusion of an organic nitrate ignition improver.

Therefore, it is known in the prior art that there are emissions advantages in using fuel-water emulsions, and in using Fischer-Tropsch (e.g. SMDS) diesel product. It is also known that ignition delay or lag is longer and cetane number is lower with emulsions based on conventional fuel than with non-emulsified conventional fuel.

However, it has now been found that when using water-in-fuel emulsions, in which the fuel component comprises a Fischer-Tropsch diesel product, certain engine performance advantages are achieved. Such performance advantages are in particular that emissions, for example of NO_x , black smoke and/or particulate matter (PM), are lower as compared to conventional fuels but without lengthening the ignition delay and reducing the

cetane number. This is achieved without the need for, or at reduced levels of, ignition improving additives, and without engine modifications. These characteristics for such emulsions have not been described in the prior art.

5 In accordance with the present invention there is provided a water-in-fuel emulsion composition comprising a Fischer-Tropsch derived fuel and water, wherein the ignition quality of said emulsion falls within the range specified in EN590.

10 EN590 is the European Standard for automotive diesel fuels.

 By "ignition quality" is meant ignition delay and cetane number.

 Said composition preferably contains no ignition
15 improving additive.

 Although in accordance with the present invention it is preferred that the fuel used is a Fischer-Tropsch derived fuel, the present invention contemplates a blend of said Fischer-Tropsch derived fuel with a conventional
20 base fuel.

 Such a conventional base fuel may typically comprise liquid hydrocarbon middle distillate fuel oil(s), for instance petroleum derived gas oils. Such fuels will typically have boiling points within the usual diesel
25 range of 150 to 400°C, depending on grade and use. It will typically have a density from 0.75 to 0.9 g/cm³, preferably from 0.8 to 0.86 g/cm³, at 15°C (e.g. ASTM D4502 or IP 365) and a cetane number (ASTM D613) of from 35 to 80, more preferably from 40 to 75. It will
30 typically have an initial boiling point in the range 150 to 230°C and a final boiling point in the range 290 to 400°C. Its kinematic viscosity at 40°C (ASTM D445) might suitably be from 1.5 to 4.5 mm²/s.

In accordance with the present invention there is also provided the use in a compression ignition engine of a water-in-fuel emulsion composition for the purpose of reducing the ignition delay in the engine, said
5 composition comprising a Fischer-Tropsch derived fuel and water.

In accordance with the present invention there is further provided the use in a compression ignition engine of a water-in-fuel emulsion composition for the purpose
10 of reducing the emission of NO_x , said composition comprising a Fischer-Tropsch derived fuel and water.

In accordance with the present invention there is further provided the use in a compression ignition engine of a water-in-fuel emulsion composition for the purpose
15 of reducing the emission of black smoke and/or particulate matter, said composition comprising a Fischer-Tropsch derived fuel and water.

In this specification, "reduce" and "reducing" mean as compared to one or more of the use of a Fischer-Tropsch derived fuel, the use of a conventional, that is,
20 petroleum derived, fuel, the use of a water-in-fuel emulsion composition based on such a conventional fuel, and the use of a fuel-in-water emulsion composition based on such a conventional fuel or on such a Fischer-Tropsch
25 derived fuel, as appropriate.

In accordance with the present invention there is yet further provided the use in a water-in-fuel emulsion composition of a Fischer-Tropsch derived fuel so as to reduce, in a compression ignition engine in which it is
30 used, emissions of NO_x , black smoke and/or particulate matter, whilst maintaining the ignition quality of the emulsion.

By "maintaining the ignition quality" is meant maintaining the ignition delay and the cetane number within the ranges specified in EN590.

5 In accordance with the present invention there is still further provided a method of reducing emissions of NO_x and/or black smoke and/or particulate matter in a compression ignition engine, as compared to that when using a conventional fuel having a specification in accordance with EN590, but without reducing the ignition
10 quality, which comprises replacing said fuel in said engine by a water-in-fuel emulsion composition which comprises a Fischer-Tropsch derived fuel and water.

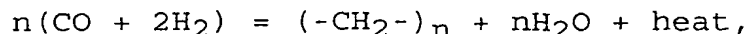
The present invention also contemplates reducing emissions by replacing in a compression ignition engine
15 other petroleum derived hydrocarbon fuels, a Fischer-Tropsch derived fuel, a water-in-fuel emulsion composition based on such a conventional fuel, or a fuel-in-water emulsion composition based on such a conventional fuel or on such a Fischer-Tropsch derived
20 fuel.

In accordance with the present invention there is yet further provided a method of operating a compression ignition engine comprising including in said engine a water-in-fuel emulsion composition which comprises a
25 Fischer-Tropsch derived fuel and water.

The Fischer-Tropsch derived fuel should be suitable for use as a diesel fuel. Its components (or the majority, for instance 95 % w/w or greater, thereof) should therefore have boiling points within the typical
30 diesel fuel ("gas oil") range, ie, from about 150 to 400 °C or from 170 to 370 °C. It will suitably have a 90 % v/v distillation temperature (T₉₀) of from 300 to 370 °C.

By "Fischer-Tropsch derived" is meant that the fuel is, or derives from, a synthesis product of a Fischer-

Tropsch condensation process. The Fischer-Tropsch reaction converts carbon monoxide and hydrogen into longer chain, usually paraffinic, hydrocarbons :



5 in the presence of an appropriate catalyst and typically at elevated temperatures (eg, 125 to 300 °C, preferably 175 to 250 °C) and/or pressures (eg, 5 to 100 bar, preferably 12 to 50 bar). Hydrogen:carbon monoxide ratios other than 2:1 may be employed if desired.

10 The carbon monoxide and hydrogen may themselves be derived from organic or inorganic, natural or synthetic sources, typically either from natural gas or from organically derived methane.

A gas oil product may be obtained directly from the
15 Fischer-Tropsch reaction, or indirectly for instance by fractionation of a Fischer-Tropsch synthesis product or from a hydrotreated Fischer-Tropsch synthesis product. Hydrotreatment can involve hydrocracking to adjust the boiling range (see, eg, GB-B-2077289B and EP-A-0147873)
20 and/or hydroisomerisation which can improve cold flow properties by increasing the proportion of branched paraffins. EP-A-0583836 describes a two-step hydrotreatment process in which a Fischer-Tropsch synthesis product is firstly subjected to hydroconversion
25 under conditions such that it undergoes substantially no isomerisation or hydrocracking (this hydrogenates the olefinic and oxygen-containing components), and then at least part of the resultant product is hydroconverted under conditions such that hydrocracking and
30 isomerisation occur to yield a substantially paraffinic hydrocarbon fuel. The desired gas oil fraction(s) may subsequently be isolated for instance by distillation.

Other post-synthesis treatments, such as polymerisation, alkylation, distillation, cracking-

decarboxylation, isomerisation and hydroreforming, may be employed to modify the properties of Fischer-Tropsch condensation products, as described for instance in US-A-4125566 and US-A-4478955.

5 Typical catalysts for the Fischer-Tropsch synthesis of paraffinic hydrocarbons comprise, as the catalytically active component, a metal from Group VIII of the periodic table, in particular ruthenium, iron, cobalt or nickel. Suitable such catalysts are described for instance in
10 EP-A-0583836 (pages 3 and 4).

 An example of a Fischer-Tropsch based process is the SMDS (Shell Middle Distillate Synthesis) described in "The Shell Middle Distillate Synthesis Process", van der Burgt et al (paper delivered at the 5th Synfuels
15 Worldwide Symposium, Washington DC, November 1985; see also the November 1989 publication of the same title from Shell International Petroleum Company Ltd, London, UK). This process (also sometimes referred to as the ShellTM "Gas-to-Liquids" or "GTL" technology) produces middle
20 distillate range products by conversion of a natural gas (primarily methane) derived synthesis gas into a heavy long-chain hydrocarbon (paraffin) wax which can then be hydroconverted and fractionated to produce liquid transport fuels such as the gas oils useable in diesel
25 fuel compositions. A version of the SMDS process, utilising a fixed-bed reactor for the catalytic conversion step, is currently in use in Bintulu, Malaysia and its products have been blended with petroleum derived gas oils in commercially available automotive fuels.

30 Gas oils prepared by the SMDS process are commercially available from the Royal Dutch/Shell Group of Companies. Further examples of Fischer-Tropsch derived gas oils are described in EP-A-0583836, EP-A-1101813, WO-A-97/14768, WO-A-97/14769,

WO-A-00/20534, WO-A-00/20535, WO-A-01/11116,
WO-A-01/11117, WO-A-01/83406, WO-A-01/83641,
WO-A-01/83647, WO-A-01/83648 and US-A-6204426.

Suitably, in accordance with the present invention,
5 the Fischer-Tropsch derived gas oil will consist of at
least 70 % w/w, preferably at least 80 % w/w, more
preferably at least 90 % w/w, most preferably at least 95
% w/w, of paraffinic components, preferably iso- and
linear paraffins. The weight ratio of iso-paraffins to
10 normal paraffins will suitably be greater than 0.3 and
may be up to 12; suitably it is from 2 to 6. The actual
value for this ratio will be determined, in part, by the
hydroconversion process used to prepare the gas oil from
the Fischer-Tropsch synthesis product. Some cyclic
15 paraffins may also be present.

By virtue of the Fischer-Tropsch process, a Fischer-
Tropsch derived gas oil has essentially no, or
undetectable levels of, sulphur and nitrogen. Compounds
containing these heteroatoms tend to act as poisons for
20 Fischer-Tropsch catalysts and are therefore removed from
the synthesis gas feed. Further, the process as usually
operated produces no or virtually no aromatic components.
The aromatics content of a Fischer-Tropsch gas oil, as
determined for instance by ASTM D4629, will typically be
25 below 1 % w/w, preferably below 0.5 % w/w and more
preferably below 0.1 % w/w.

The Fischer-Tropsch derived gas oil used in the
present invention will typically have a density from 0.76
to 0.79 g/cm³ at 15 °C; a cetane number (ASTM D613)
30 greater than 70, suitably from 74 to 85; a kinematic
viscosity (IP71/ASTM D445) from 2 to 4.5, preferably 2.5
to 4.0, more preferably from 2.9 to 3.7, mm²/s at 40°C;
and a sulphur content (ASTM D2622) of 5 ppmw (parts per
million by weight) or less, preferably of 2 ppmw or less.

Preferably it is a product prepared by a Fischer-Tropsch methane condensation reaction using a hydrogen/carbon monoxide ratio of less than 2.5, preferably less than 1.75, more preferably from 0.4 to 1.5, and ideally using a cobalt containing catalyst. Suitably it will have been obtained from a hydrocracked Fischer-Tropsch synthesis product (for instance as described in GB-B-2077289 and/or EP-A-0147873), or more preferably a product from a two-stage hydroconversion process such as that described in EP-A-0583836 (see above). In the latter case, preferred features of the hydroconversion process may be as disclosed at pages 4 to 6, and in the examples, of EP-A-0583836.

In said water-in-fuel emulsion composition of the present invention, the water is present preferably in an amount of at least 1%, preferably 1 to 50%, more preferably 5 to 35%, most preferably 10 to 35%, by weight of the emulsion composition.

Said water-in-fuel emulsion composition preferably contains one or more emulsifiers, such as ionic or non-ionic surfactants. Suitable surfactants are as described below. Such emulsifier(s) is/are preferably present in the amount of at least 1%, more preferably 1 to 10%, still more preferably 1 to 7%, by weight of the emulsion composition.

The present invention is particularly applicable where the fuel composition is used or intended to be used in a direct injection or an indirect injection diesel engine, for example of the rotary pump, electronic unit injector or common rail type. It may be of particular value for rotary pump engines, and in other diesel engines which rely on mechanical actuation of the fuel injectors and/or a low pressure pilot injection system.

Diesel fuel-water emulsions have been used in order to improve the emissions performance of diesel fuels. It

is also known to use emulsions to reduce the emissions levels of low quality diesel fuel, e.g. marine or industrial diesel fuels, to acceptable levels.

5 However, a drawback of diesel fuel-water emulsions is that water causes a considerable lowering of the cetane number (i.e. ignition quality) of the fuel as compared to that of diesel fuel.

10 It has now been found that as Fischer-Tropsch (e.g. SMDS) derived fuels have an intrinsically high cetane number, greater than 75, an acceptable ignition quality of a fuel-water emulsion can be achieved by use of a Fischer-Tropsch derived fuel in such an emulsion.

15 Furthermore, because of such high cetane numbers of Fischer-Tropsch derived fuels, emulsions containing them can in fact contain higher levels of water than are customarily used in fuel-water emulsions, so providing fuels with very low, or even zero, particulate emissions.

20 The SMDS reaction products suitably have boiling points within the typical diesel fuel range (between 150 and 370 °C), a density of between 0.76 and 0.79 g/cm³ at 15°C, a cetane number greater than 72.7 (typically between 75 and 82), a sulphur content of less than 5 ppmw, a viscosity between 2.9 and 3.7 mm²/s at 40 °C and an aromatics content of no greater than 1 % w/w.

25 The emulsion composition of the present invention may, if required, contain one or more additives as described below.

30 Detergent-containing diesel fuel additives are known and commercially available, for instance from Infineum (eg, F7661 and F7685) and Octel (e,g. OMA 4130D). Such additives may also be added to diesel fuels at relatively low levels (their "standard" treat rates providing typically less than 100 ppmw active matter detergent in

the overall additivated fuel composition) intended merely to reduce or slow the build up of engine deposits.

5 Examples of detergents suitable for use in fuel additives for the present purpose include polyolefin substituted succinimides or succinamides of polyamines, for instance polyisobutylene succinimides or polyisobutylene amine succinamides, aliphatic amines, Mannich bases or amines and polyolefin (eg, polyisobutylene) maleic anhydrides. Succinimide
10 dispersant additives are described for example in GB-A-960493, EP-A-0147240, EP-A-0482253, EP-A-0613938, EP-A-0557561 and WO-A-98/42808. Particularly preferred are polyolefin substituted succinimides such as polyisobutylene succinimides.

15 The additive may contain other components in addition to the detergent. Examples are lubricity enhancers; anti-foaming agents (eg, the polyether-modified polysiloxanes commercially available as TEGOPREN™ 5851 and Q 25907 (ex Dow Corning), SAG™ TP-325
20 (ex OSi), or RHODORSIL™ (ex Rhone Poulenc)); ignition improvers (cetane improvers) (eg, 2-ethylhexyl nitrate (EHN), cyclohexyl nitrate, di-tert-butyl peroxide and those disclosed in US-A-4208190 at column 2, line 27 to column 3, line 21); anti-rust agents (eg, that sold
25 commercially by Rhein Chemie, Mannheim, Germany as "RC 4801", a propane-1, 2-diol semi-ester of tetrapropenyl succinic acid, or polyhydric alcohol esters of a succinic acid derivative, the succinic acid derivative having on at least one of its alpha-carbon atoms an unsubstituted
30 or substituted aliphatic hydrocarbon group containing from 20 to 500 carbon atoms, eg, the pentaerythritol diester of polyisobutylene-substituted succinic acid); corrosion inhibitors; reodorants; anti-wear additives; anti-oxidants (eg, phenolics such as 2,6-di-tert-

butylphenol, or phenylenediamines such as N,N'-di-sec-butyl-p-phenylenediamine); and metal deactivators.

It is particularly preferred that the additive include a lubricity enhancer, especially when the fuel composition has a low (eg, 500 ppmw or less) sulphur content. In the additivated fuel composition, the lubricity enhancer is conveniently present at a concentration between 50 and 1000 ppmw, preferably between 100 and 1000 ppmw. Suitable commercially available lubricity enhancers include EC 832 and PARADYNE™ 655 (ex Infineum), HITEC™ E580 (ex Ethyl Corporation), VEKTRON™ 6010 (ex Infineum) and amide-based additives such as those available from the Lubrizol Chemical Company, for instance LZ 539 C. Other lubricity enhancers are described in the patent literature, in particular in connection with their use in low sulphur content diesel fuels, for example in:

- the paper by Danping Wei and H.A. Spikes, "The Lubricity of Diesel Fuels", Wear, III (1986) 217-235;

- WO-A-95/33805 - cold flow improvers to enhance lubricity of low sulphur fuels;

- WO-A-94/17160 - certain esters of a carboxylic acid and an alcohol wherein the acid has from 2 to 50 carbon atoms and the alcohol has 1 or more carbon atoms, particularly glycerol monooleate and di-isodecyl adipate, as fuel additives for wear reduction in a diesel engine injection system;

- US-A-5484462 - mentions dimerised linoleic acid as a commercially available lubricity agent for low sulphur diesel fuel (column 1, line 38), and itself provides aminoalkylmorpholines as fuel lubricity improvers;

- US-A-5490864 - certain dithiophosphoric diester-dialcohols as anti-wear lubricity additives for low sulphur diesel fuels; and

- WO-A-98/01516 - certain alkyl aromatic compounds having at least one carboxyl group attached to their aromatic nuclei, to confer anti-wear lubricity effects particularly in low sulphur diesel fuels.

5 It is also preferred that the additive contain an anti-foaming agent, more preferably in combination with an anti-rust agent and/or a corrosion inhibitor and/or a lubricity additive.

10 Unless otherwise stated, the (active matter) concentration of each such additional component in the additivated fuel composition is preferably up to 1 % w/w, more preferably in the range from 5 to 1000 ppmw, advantageously from 75 to 300 ppmw, such as from 95 to 150 ppmw.

15 The (active matter) concentrations of components (with the exception of the ignition improver) will each preferably be in the range from 0 to 20 ppmw, more preferably from 0 to 10 ppmw. The (active matter) concentration of any ignition improver present will
20 preferably be between 0 and 600 ppmw and more preferably between 0 and 500 ppmw.

 The additive will typically contain the detergent, optionally together with other components as described above, and a diesel fuel-compatible diluent, which may be
25 a carrier oil (eg, a mineral oil), a polyether, which may be capped or uncapped, a non-polar solvent such as toluene, xylene, white spirits and those sold by member companies of the Royal Dutch/Shell Group under the trade mark "SHELLSOL", and/or a polar solvent such as an ester
30 and, in particular, an alcohol, eg, hexanol, 2-ethylhexanol, decanol, isotridecanol and alcohol mixtures such as those sold by member companies of the Royal Dutch/Shell Group under the trade mark "LINEVOL", especially LINEVOL™ 79 alcohol which is a mixture of C7-9

primary alcohols, or the C₁₂₋₁₄ alcohol mixture commercially available from Sidobre Sinnova, France under the trade mark "SIPOL".

5 The additive may be suitable for use in heavy and/or light duty diesel engines.

The Fischer-Tropsch fuel may be used in combination with any other fuel suitable for use in a diesel engine. It will typically have an initial distillation temperature of about 160 °C and a final distillation
10 temperature of between 290 and 360 °C, depending on its grade and use. Vegetable oils may also be used as diesel fuels *per se* or in blends with hydrocarbon fuels.

The fuel may itself be additivated (additive-
containing) or unadditivated (additive-free). If
15 additivated, it will contain minor amounts of one or more additives selected for example from anti-static agents, pipeline drag reducers, flow improvers (eg, ethylene/vinyl acetate copolymers or acrylate/maleic anhydride copolymers) and wax anti-settling agents (eg,
20 those commercially available under the Trade Marks "PARAFLOW" (eg, PARAFLOW™ 450, ex Infineum), "OCTEL" (eg, OCTEL™ W 5000, ex Octel) and "DODIFLOW" (eg, DODIFLOW™ v 3958, ex Hoechst).

In accordance with the present invention there is
25 also provided a process for the preparation of a water-in-fuel emulsion composition which process comprises admixing a Fischer-Tropsch derived fuel with water, wherein the water is present preferably in an amount of at least 1%, more preferably 1 to 50%, still
30 more preferably 5 to 35%, yet more preferably 10 to 35%, by weight of the emulsion composition.

Said process preferably includes admixing with said Fischer-Tropsch derived fuel and water an emulsifier such as a surfactant. Said surfactant may be an ionic or non-

ionic surfactant, preferably the latter. Such a non-ionic surfactant is preferably selected from alkoxylates, such as alcohol ethoxylates and alkylphenol ethoxylates; carboxylic acid esters, such as glycerol esters and
5 polyoxyethylene esters; anhydrosorbitol esters, such as ethoxylated anhydrosorbitol esters; natural ethoxylated fats, oils and waxes; glycol esters of fatty acids; alkyl polyglycosides; carboxylic amides, such as diethanolamine condensates and monoalkanolamine condensates; fatty acid
10 glucamides; polyalkylene oxide block copolymers and poly(oxyethylene-co-oxypropylene) non-ionic surfactants. Alternatively, a mixture of surfactants can be used. It is preferred that the HLB (hydrophile-lipophile balance) value of the surfactant or mixture of surfactants is in
15 the range 3 to 9, more preferably 3 to 6. In the case of a mixture of surfactants, the HLB of the mixture is dependent on the proportions of the surfactants in the mixture and their respective HLB values, and is preferably in the ranges given above.

20 Particularly suitable non-ionic surfactants include SPAN 85 (sorbitan trioleate, ex. Uniqema, HLB 1.8), SPAN 65 (sorbitan tristearate, ex. Uniqema, HLB 2.1), KESSCO PGMS PURE (propylene glycol monostearate, ex. Stepan, HLB 3.4), KESSCO GMS 63F (glycerol monostearate, ex. Stepan,
25 HLB 3.8), SPAN 80 (sorbitan monooleate, ex. Uniqema, HLB 4.3), SPAN 60 (sorbitan monostearate, ex. Uniqema, HLB 4.7), BRIJ 52 (polyoxyethylene (2) cetyl ether, ex. Uniqema, HLB 5.3) and SPAN 20 (sorbitan monolaurate, ex. Uniqema, HLB 8.6). Further suitable non-ionic
30 surfactants, which may be used in suitable proportions in mixtures having the preferred HLB values, include ALDO MSA (glycerol monostearate, ex. Lonza, HLB 11), RENEX 36 (polyoxyethylene (6) tridecyl ether, ex. Uniqema, HLB 11.4), BRIJ 56 (polyoxyethylene (10) cetyl ether, ex.
35 Uniqema, HLB 12.9), TWEEN 21 (polyoxyethylene (4)

sorbitan monolaurate, ex. Uniqema, HLB 13.3), RENEX 30 (polyoxyethylene (12) tridecyl ether, ex. Uniqema, HLB 14.5) and BRIJ 58 (polyoxyethylene (20) cetyl ether, ex. Uniqema, HLB 15.7).

5 The present invention will now be described with reference to the following examples.

Method of preparing Fischer-Tropsch (SMDS) water-in-fuel emulsions

10 The emulsion fuels used to generate the emissions and combustion data referred to in this specification were prepared in 1-litre batches as follows:

Table 1

Sample name	SMDS diesel	SPAN 80*	TWEEN 21**	Water***
0% water	705g	22.5g	22.5g	None
10% water	651g	23.2g	23.2g	77.5g
20% water	592g	24.0g	24.0g	160.0g
30% water	528g	24.7g	24.7g	247.5g
35% water	494g	25.0g	25.0g	294.0g

15 * Sorbitan monooleate

 ** Polyoxyethylenesorbitan monolaurate

 *** Laboratory grade from a Millipore RO/MilliQ⁺ water purification system

20 Emulsion preparation method

 The required amount of SMDS diesel, non-ionic surfactants SPAN 80 (HLB 4.3) and TWEEN 21 (HLB 13.3) were added to a 2.5 litre Pyrex glass beaker, tall form. The beaker was set under a Silverson High Shear
25 laboratory mixer, Model L2R, fitted with standard mixing head and emulsor screen. The contents were mixed for 30 seconds to disperse the emulsifiers. Mixing was continued at full speed whilst adding gradually, over a period of approximately 1 minute, the predetermined

quantity of water. Mixing was continued until 5 minutes had elapsed since the first addition of water. Weight measurements were carried out using an electronic top-pan balance (Oertling GC32).

5 The emulsion fuels prepared by this method remained stable as milky-white homogeneous mixtures for at least 48 hours before significant phase separation was observed. Engine testing was carried out within 48 hours of preparation.

10 The usual method for measuring the ignition quality of diesel fuels (Cetane Number - ASTM D613) is inappropriate in respect of diesel-water emulsions. However, in the AVL/LEF 5312 engine used for emissions measurements it was possible to measure ignition delay,
15 of which cetane number is effectively a measurement.

 The AVL/LEF 5312 engine is a diesel research engine manufactured by AVL/LEF, based on a Volvo D12 unit. The fuel injection system employs ECU-controlled unit injection. An intake boost compressor is fitted, and the
20 engine can be operated with or without supercharging. The engine was set up to Euro II emissions standard. The engine specification is shown in Table 2:

Table 2

Type	Single cylinder, water cooled, 4 stroke, OHC 4V, DI diesel engine
Swept volume	2022 cm ³
Bore	131 mm
Stroke	150 mm
Nominal compression ratio	17.8:1
Maximum speed	3000 rpm
Maximum charge pressure	300 kPa absolute
Maximum power (boosted)	48 kW @ 1800 rpm
Maximum torque (boosted)	311 Nm @ 1200 rpm

Maximum cylinder pressure	18 MPa
---------------------------	--------

Emissions analysis equipment comprised a Horiba EXSA1500EGR analyser, an AVL 439 opacity meter and an AVL 415 smoke meter. A Richard Oliver partial flow
5 particulates tunnel provided dilution for particulate filter measurements.

The fuelling system was designed to allow rapid switching between a variety of sources of fuel and a procedure was adopted which allowed smoke tests to be
10 routinely performed on only 1 litre of test fuel. The procedure allowed each test fuel to be bracketed by tests with a reference fuel, thus providing a convenient way to normalise results and compare the performance of different fuels while accounting for day-to-day variation
15 in engine response.

The operating conditions for the AVL/LEF engine were as set out in Table 3:

Table 3

Torque set point, Nm	130
Speed set point, rpm	1200
Coolant set point, °C	80
Air intake temperature, °C	35
Air intake pressure, kPa	...
Exhaust pressure, kPa	...
Injection timing, ° crank angle	1 BTDC

The test procedure was as set out in Table 4:

Table 4

Step	Duration	Fuel
1. Warm up	20 minutes	Base
2. Stabilise at test condition	12 minutes	Base
3. Data collection	8 X 30 seconds then average	Base
4. Flush	1 minute	Test fuel 1
5. Stabilise at test condition	1 minute	Test fuel 1
6. Data collection	8 x 30 seconds then average	Test fuel 1
7. Flush	1 minute	Base
8. Stabilise at test condition	6.5 minutes	Base
9. Data collection	8 x 30 seconds then average	Base
10. Loop to Step 4 for remaining test fuels		

5 The SMDS fuel was a high quality synthetic fuel derived from natural gas by the Fischer-Tropsch process, the properties of which were as set out in Table 5:

Table 5

Density @ 15°C (IP365/ASTM D4502)	0.776 g/cm ³
Distillation (IP23/ASTM D86):	
Initial boiling point	183°C
T50	275°C
T90	340°C
Final boiling point	359°C
Cetane number (ASTM D613)	
	81
Kinematic viscosity @ 40°C (IP71/ASTM D445)	3.10 mm ² /s
Cloud point (IP219)	0°C
Sulphur (ASTM D2622)	< 2 mg/kg
Aromatic content (IP391 Mod)	< 0.1% _m
Flash point	73°C

5 Emissions data for black smoke (filter smoke number and opacity) and nitrogen oxides (NO_x) for the emulsion fuels listed in Table 1 above are set out in Table 6:

Table 6

wt% water	AVL smoke number	Opacity, %	NO _x , ppm
0	1.59	6.55	543
10	0.42	1.46	537
20	0.07	0.25	484
30	0.02	0.07	429
35	0.01	0.04	379

10 From Table 6, it can be seen that, for an emulsion containing 35% water, the smoke number and opacity, which are both measures of black smoke and/or particulates, are

both virtually zero. Moreover, NO_x levels are much lower as compared to those for non-emulsified SMDS fuel.

Expressed in an alternative way, as shown in Table 7:

Table 7

	% reduction in emissions relative to SMDS		
wt% water	AVL smoke number	Opacity	NO_x
10	-74%	-78%	-1.1%
20	-96%	-96%	-11%
30	-99%	-99%	-21%
35	-99+%	-99+%	-30%

From Table 7, it can be seen that for an emulsion containing, for example, 35% water, the reduction in smoke number and opacity as compared to that for non-emulsified SMDS fuel is over 99%, and that for NO_x is 30%.

Ignition delay was computed using an AVL 670 Indimaster, a multiple channel indicating system specifically designed for use with compression ignition engines. In this application, it is the parameter defined as the delay between start of injection and start of combustion that is of interest.

The start of combustion is determined from the differential heat release curve. This is derived from the cylinder pressure using the first law of thermodynamics. Due to the fuel injection, the heat release curve dips into the negative range before its steep rise. The subsequent zero pass is taken to be start of combustion.

In electronic unit injector systems, the start of injection is defined by the injector solenoid closing point. The solenoid is triggered by a signal from the

electronic control unit (ECU). In this application, the ECU signal is recorded as a trace that is displayed on the Indimaster. Due to the lag between when the signal is measured and when the pulse actually triggers the solenoid, an offset occurs between apparent and actual start of injection. The offset is a constant time and therefore increases in terms of degrees crank angle with rising engine speed. At the standard test engine speed of 1200 rpm, it has been established that the actual start of injection occurs 10.2 degrees after the recorded start of injection. A simple formula has been built into the Indimaster to correct the ignition delay (in degrees of crank angle) which is:

$$\text{Ignition delay} = \text{Start of combustion} - (10.2 + \text{injection start})$$

Table 8 shows ignition delays for a series of emulsions of SMDS and water, stabilised by an emulsifier additive. For comparison purposes, the delay measured under identical conditions for a fuel of known cetane number has been included.

From Table 8, it can be seen that, as the proportion of water in the water-in-fuel emulsion composition is increased, the ignition delay also increases, i.e. the cetane number decreases. However, it can also be seen that, even when the water-in-fuel emulsion composition contains 35% water, the ignition delay is lower than that of Swedish Class 1 diesel, of which the ignition delay is 2.6 (and the cetane number is 54). Therefore, a water-in-fuel emulsion containing 35% water not only exhibits virtually zero smoke number and opacity, but also a superior ignition delay compared to that of Swedish Class 1 diesel, the latter being regarded as a "clean" diesel.

TABLE 8

wt% water	Ignition delay (degrees of crank angle)	Cetane number
0	1.7	
10	1.8	
20	2.05	
30	2.15	
35	2.4	
Swedish Class I diesel	2.6	54

N.B. A decreasing ignition delay means an increasing cetane number.

5

The properties of a typical Swedish Class 1 diesel fuel are set out in Table 9:

Table 9

Density @ 15°C (IP365/ASTM D4502)	0.8150 g/cm ³
Distillation (IP23/ASTM D86):	
Initial boiling point	186.0°C
T50	235.0°C
T90	264.0°C
Final boiling point	290.5°C
Cetane number (ASTM D613)	
Kinematic viscosity @ 40°C (IP71/ASTM D445)	2.030 mm ² /s
Cloud point (IP219)	-32°C
CFPP (IP309)	-37°C
Sulphur (ASTM D2622)	<5 mg/kg
Aromatic content (IP391 Mod)	4.4% _m
Flash point	74°C

THIS PAGE BLANK (USPTO)

C L A I M S

1. A water-in-fuel emulsion composition comprising a Fischer-Tropsch derived fuel and water, wherein the ignition quality of said emulsion falls within the range specified in EN590.
- 5 2. A composition according to claim 1 which contains no ignition improving additive.
3. A composition according to claim 1 or 2 which contains an emulsifier.
4. The use in a compression ignition engine of a
10 water-in-fuel emulsion composition for the purpose of reducing the ignition delay in the engine, said composition comprising a Fischer-Tropsch derived fuel and water.
5. The use in a compression ignition engine of a
15 water-in-fuel emulsion composition for the purpose of reducing the emission of NO_x, said composition comprising a Fischer-Tropsch derived fuel and water.
6. The use in a compression ignition engine of a water-in-fuel emulsion composition for the purpose of
20 reducing the emission of black smoke and/or particulate matter, said composition comprising a Fischer-Tropsch derived fuel and water.
7. The use in a water-in-fuel emulsion composition of a Fischer-Tropsch derived fuel so as to reduce, in a
25 compression ignition engine in which it is used, emissions of NO_x, black smoke and/or particulate matter, whilst maintaining the ignition quality of the emulsion.
8. A method of reducing emissions of NO_x and/or black smoke and/or particulate matter in a compression ignition
30 engine, as compared to that when using a conventional

fuel having a specification in accordance with EN590, but without reducing the ignition quality, which comprises replacing said fuel in said engine by a water-in-fuel emulsion composition which comprises a Fischer-Tropsch derived fuel and water.

9. A method of operating a compression ignition engine comprising including in said engine a water-in-fuel emulsion composition which comprises a Fischer-Tropsch derived fuel and water.

10. A process for the preparation of a diesel fuel composition which process comprises admixing a Fischer-Tropsch derived fuel with water.

A B S T R A C T

Diesel fuel compositions

5 A water-in-fuel emulsion composition comprising a
Fischer-Tropsch derived fuel and water, and its use in a
compression ignition engine. Emissions, for example of
NO_x, black smoke and/or particulate matter, are lower as
compared to conventional fuels but without lengthening
the ignition delay and reducing the cetane number. This
is achieved without the need for, or at reduced levels
of, ignition improving additives, and without engine
modifications.

10

THIS PAGE BLANK (USPTO)